Quality Control

DQA:

Date:

NCR:	Yes	1	No
IVCIV.	162	/	110

NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORM	ANCE / UPI	DATE		•		•	4
												QA	Closed:	Dat	:e:	
Vork Orde	ŕ: _				·		DISPOSITION				AGAINST I	DEPAR	TMENT	-		
Part No						Rework Skid-tube Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab		Machining	Crosstube Small Fab Finishing Composite	_ _ _	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root		ì			Desc	rip	iption of work order update		Initial Action			S	ign &			
Cause		Date	Step	Qty		0	r Non-conformance	Chief Eng		Descr	ription		Date	Verification	۱	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved																
								AUL	T CATE	GORY						
Landin		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped t n Strip in Bend Vaves in E	Tube Extrusion	-		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	on Incomplete ions Incomplete/l nance led I	Unclear	Ove Par Par Par Pos	alized er/Under t Incorrec t Lost/Mi t Moved itioned W ver Loss/S	issing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence					ı	Finish	1	Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-17-13 1:30:21 PM

Item ID:

D3015-3

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Locknut

Required Date: 10/18/13

10/18/13

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan: _____ Date: ____

Operation

Date: _____

Tooling:

Date: Date: Run Start

Stop

Sequence ID/ **Work Center ID**

130

Description

Identify as per dwg & Stock Location: 57023

Set Up/ **Run Hours**

Tool # Plan Code

Accept Qty Qty

Reject Reject

Insp. Number Stamp

130 Packaging

Memo

0.00

0.00

SPC (Y/N):

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

Quality Control

Memo

0.00

1 M 13-10-28 NF 13-10-28

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Action Sign & Initial Root Chief Eng Date Qty or Non-conformance Description Date Verification QC Inspector Cause Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

	· ·
H:/FORMS/Quality Assurance	\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

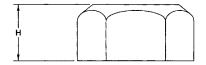
Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

	PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
,	D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
- 1	D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
	D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
ĉ\ ا	D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000

108415MLJ 13-10-22



С

NOTES:
1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
2) FINISH: NIA
3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NIA
6) IDENTIFICATION: NONE
7) WEIGHT: NIA

С	REFOR!	MAT DWG, -7 51 (ZN B8-1),	СР	09.07.08				
В	ADD D3	015-7	KJ	03.07.15				
Α	NEW IS	SUE	DS	01.05.03				
REV.			BY	DATE				
DESIG	Z	d	DART AFROSP	DART AEROSPACE LTD				
DRAWN (2)			HAWKESBURY, ONTARIO, CANADA					
CHECKED		1	DRAWING NO. F		REV. C			
MFG. APPR.		W.	D3015		SHEET 1 OF 1			
APPROVED -		-#4	TITLE		SCALE			

DATE 09.07.08 COPYRIGHT © 2001 BY DART AEROSPACE LTD
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DE APPR.

LOCKNUT

Α

NTS



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO21818

Purchase Order Date 10/24/2013 PO Print Date 10/24/2013

Page Number 1 of 1

Order From:

ACKLANDS - GRAINGER INC.

P.O. BOX 2970

WINNIPEG, MB R3C 4B5

VC-ACK001

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

613 632 2739

Delivered

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607 Net 30

Terms Currency

CAD

FOB

FCA - (Free Carrier)

Ship Via:

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extende Pric
l	FLMN021-005-000 * AS PER DWG D3015 REV. C B108429	Locknut	10/29/2013 Yes 10/29/2013	100.00 Each	\$0.09	\$9.0
2	PFS-LNNC5/16S1 AS PER DWG D3015 REV. C B108415	Lock Nut	10/29/2013 Yes 10/29/2013	100.00 Each	Line Total: \$0.12	\$9.0 \$12.0

Line Total:

PO Total:

\$21.0

NO

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES

PST# 6122-5207

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Change Nbr:

Change Date:

10/24/2013

\$12.0

ACKLANDS ACKLANDS - GRAINGER INC. PACKING SLIP ONLY INVOICE TO FOLLOW ENVOY ACKLANDS - GRAINGER INC. PO BOX 2970 765 CAMERON ST. GRAINGER. **HAWKESBURY ON K6A 2B7** PACKING SLIP# (613) 632-2739 **WINNIPEG MB R3C 4B5** 1417 0429854 EXPED FACTU T O S H I P В DART AEROSPACE LTD **DART AEROSPACE LTD** 1270 ABERDEEN ST 1270 ABERDEEN ST **HAWKESBURY HAWKESBURY** ON E K6A 1K7 **K6A 1K7** À À NO. DU CLIENT CUST. NO. NO DE REFERENCE DU CLIENT CUST. REF. NO. NO. DE LICENSE PROVINCIALE P.S.T. LIC. NO. NO. DU CONTRAT CONTRACT NO. EXP. DIRECTE DATE DE LA COMMANDE DIR. SHIP ORDER DATE DATE DE LA FACTURE INVOICE DATE 10/25/2013 N 1726280 21818 N/A - HST APP. DE CREDIT S'APPLIQUE AU NO.DE FACTURE APPLY TO INVOICE NO. NO.DE VERSEMENTS NO. OF PMTS. TERMES TERMS M.E.P. M.B.P. VENDEUR SALESPERSON 0 0 00/00/0000 08:30 *** NET 30 *** M85 PRIX EXTENSIONNE EXTENDED PRICE MFG CODE PRIX DE LISTE SUGG. LIST QUANTITE EXPEDIEE QUANTITY SHIPPED PRIX PRICE ORDER DE COMM ORDER SEO. NO. DE PIECE ITEM NO. QUANTITE COMMANDEE QUANTITY ORDERED ESC DIS PAR PER ORDRE DE TABLETTE BIN LOCATION 0 lв 9.00 15.51 100 EA MEF 51730.050.001 ۱S 100 NUT LOC NYL 304SS 985 M5 27 s 9 397 FLMN021-005-0000 SUPERSEDED BY ABOVE ITEM NON-STOCKING ITEMS, DELIVERY TIMES WILL WARY 12.00 E 100 100 PFS LNNC516S1 20.64 12.00 NYY 100 C07E .8 55 NUT LOCK NYLON HEX NC 5/16

PAGE PAGE NO

1 of 1

10/25/2013

0.00 NYY

12.00

1.56

0.00

13.56

MONTANT FOTAL TOTAL AMOUNT

SOUS TOTAL / SUB TOTAL

9305

T.P.S / T.V.H G.S.T.M.S.T. TAXE PROV PROV. TAX

CODE DE COMM. DIF. B.O. CODE

B - B.O COMMANDE DIF. C- ANNULEE CANCEL D- EXP DIRECTE DIR. SHI

T.P.S/G.S.T

1

COPIE DU CLIENT CUSTOMER COPY

DATE DE LIVRAISION REQUISE REQUESTED DELIVERY

HST# 88970-1272/TVQ# 1019602903

SHP NV SHP COWPLETE

RECU PAR RECEIVED BY

PORT PAYE

EXPEDITEUR SHIP VIA

102

CUSTOMER PICK UP